

Work Order ID 123407

Thursday, August 07, 2014 11:14:52 AM

123407

Page 1

Item ID: D350-567-031

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Interior Window For -015 & -025

Start Date: 7/30/14

Start Qty: 1.00

1

Cust Item ID:

Required Date: 8/07/14

Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: MLJDate: 14-08-08

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

IIN-D350-567

E

SUP Label

MLJ

15-01-08

100

Document Control

0.00

100

DOCUMENT CONTROL

DC

Memo

0.00

Doc.Control -USB or Paperwork

Photocopy blue file and create labels per PPP D350-567-031 chg001

(1x)

DAS
46
9-89

JAN 09 2015

110

Packaging

0.00

110

Packaging

Memo

0.00

Packaging

Pick Packing Kit

ENSURE DT 8439 TEMPLATE IS INCLUDED

JAN 07 2015

DAS
66
9-89

120

QC4- 100% Inspect kits for completeness

0.00

120

QC

Memo

0.00

Quality Control

(1x)

DAS
46
9-89

JAN 09 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Large Fab ☐	Composite ☐	Supplier ☐																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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123407

Page 2

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Item ID: D350-567-031

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Interior Window For -015 & -025

Start Date: 7/30/14

Start Qty: 1.00

1

Cust Item ID:

Required Date: 8/07/14

Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

130

Packaging

Packaging

Packaging

Memo

Identify and pack for shipping as per PPP D350-567-031

Location:

PPP Rev:

0.00

0.00

1216

DAS

06

9-89

JAN 09 2015

140

140

QC

Quality Control

QC21- Final Inspection - Work Order Release

Memo

0.00

0.00

MCS 15-01-12
MF 15-01-09

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Picklist Print

Thursday, August 07, 2014 11:14:51 AM

Page 1

Work Order ID: 123407

123407

Parent Item: D350-567-031

D350-567-031

Parent Item Name: Interior Window For -015 & -025

Start Date: 7/30/14

Required Date: 8/07/14

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A new issue 08-04-25 DD verified by: LL
IPP Rev:B 08-10-07 as per revD DD verified by:
13.10.15 AS PER IIN REV.E DD VERF:JLM

IPP REV:C

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN526C632R12 Screw		Purchased	No			120	Each	338.0000	8	8			DAS CS 9-89
AN526C632R12													
Location Loc Qty Loc Code													
ST328 338													
m126474 100													
m128403 238													
D2463 1/2" Seal (\$Per Foot)		Manufactured	No			120	f	411.5137	3.75	8			DAS CS 9-89
D2463													
Location Loc Qty Loc Code													
ST409 411.513684													
110718 25.063684													
115701 386.45													
D3210-1 Doubler For Interior Window -015 & -025		Manufactured	No			120	Each	8.0000	1	1			DAS CS 9-89
D3210-1													
Location Loc Qty Loc Code													
ST437 8													
116906 8													
D3211-1 Bracket For Interior Window For -015 & -025		Manufactured	No			120	Each	11.0000	1	1			DAS CS 9-89
D3211-1													
Location Loc Qty Loc Code													
ST437 11													
105130 11													

JAN 08 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Crosstube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Thursday, August 07, 2014 11:14:52 AM

Page 2

Work Order ID: 123407

123407

Parent Item: D350-567-031

D350-567-031

Parent Item Name: Interior Window For -015 & -025

Start Date: 7/30/14

Required Date: 8/07/14

Start Qty: 1.00

Required Qty: 1.00

D3212-1 Manufactured No

120 Each

30.0000

1 1

D3212-1

Replacement Interior Window For -015 & -025

DAS
43
9-89

Location

Loc Qty

Loc Code

ST438

30

113221

11

113831

15

119657

4

**

DAS
06
9-89

D3213-041 Manufactured No

120 Each

9.0000

1 1

D3213-041

Replacement Interior Door For -015 & -025

DAS
46
9-89

Location

Loc Qty

Loc Code

ST438

9

106249

3

113802

4

115136

2

**

DAS
06
9-89

MS20470AD4-5 Purchased No

120 Each

2,591.000

40 40

MS20470AD4-5

RIVET, UNIVERSAL HEAD

DAS
46
9-89

Location

Loc Qty

Loc Code

ST312

2591

m128401

1653

m128813

938

**

DAS
06
9-89

MS20470AD4-6 Purchased No

120 Each

4,195.000

90 90

MS20470AD4-6

RIVET

DAS
46
9-89

Location

Loc Qty

Loc Code

ST312

4195

118927

756

m128401

436

m128754

1488

m129499

1515

**

DAS
06
9-89

JAN 08 2015

Thursday, August 07, 2014 11:14:52 AM

Shop Packet Print

Page 2

DQA: _____ Date: _____



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Doc/Data									
Equip/Tooling									
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Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Page 3

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Parent Item: D350-567-031

D350-567-031

Parent Item Name: Interior Window For -015 & -025

Start Date: 7/30/14

Required Date: 8/07/14

Start Qty: 1.00

Required Qty: 1.00

MS20470AD4-7

Purchased

No

120

Each

3,156.000

20 20

**

DAS
06
9-89

MS20470AD4-7

DAS

Rivet, Universal Head

46
9-89

Location

Loc Qty

Loc Code

ST312

3156

123525

1317

124231

539

m128228

1300

20

mf

JAN 08 2015

MS21042L06

Purchased

No

120

Each

481.0000

8 8

**

DAS
06
9-89

MS21042L06

DAS

Nut

46
9-89

Location

Loc Qty

Loc Code

ST307

481

m127304

3

m128401

78

m128976

200

m129499

200

8

mf

NAS1149DN632J

Purchased

No

120

Each

441.0000

8 8

**

DAS
06
9-89

NAS1149DN632J

DAS

Washer

46
9-89

Location

Loc Qty

Loc Code

CA

46

M129682

46

ST277

395

M126084

11

M127255

100

M128812

284

8

mf

JAN 07 2015

DQA: _____ Date: _____



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